

5/46

DART AEROSPACE LTD	Work Order:	2470.9
	Part Number:	D3162-041
Description: Bracket assembly.		
		Stack of 7
Drawing: D3162 Rev. AB	Qty:	15 19

RF 04.11.29

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JL	05.10.26	15
2	METAL / CNC-CELL	Cut Blanks. Blank size: 1.150" x 0.985" x .063" thick. Grain along .985 Matl: 6061-T6 .063" thick (M6061T6S.063)	JL	05.11.12	19
3	HAAS	Machine as per Folio FA239 Stack of 7 Batch M18556	J.L	05.11.12	19
4	QC	Inspect Level 2	J.L	05.11.13	19
5	QC	Inspect Level 8	J.L	05.11.13	19
6	METAL / CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	SAD	05/11/13	19
7A	METAL	Form as per drawing	SB	05/11/14	19
7B	GA	C'sink holes as per Dwg D3162	FF	05/11/15	19
8	FINISHING	Chemical conversion coat as per QSI 005 4.1	FF	05/11/15	19
9	STORES	Pick: Qty Part Number Description Batch 1 MS21059L3 Nutplate M12240 2 MS20426AD3-4 Rivet M15786	FF	05/11/15	19
10	METAL	Assemble as per drawing	FF	05/11/15	19
11	QC	Inspect Level 5	J	05.11.16	19
12	STORES	Identify and stock with PIN + B/N using fine point permanent ink marker LSC SK	P	05/11/16	19
13	EXPEDITING	Close W/O Inspect level 21 Cost/part .98 545 05/11/21 19 2.66	D	05/11/21	19

RF
04.11.29

C2

Rev	Date	Change	Revised By	Approved
A	02.05.14	New Issue	NG	CE 2002/5/2002
A1	03.03.20	Added c'sink	FF	

RELEASED

02/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DE Date: 05/11/21
 QA: N/C Closed: _____ Date: _____

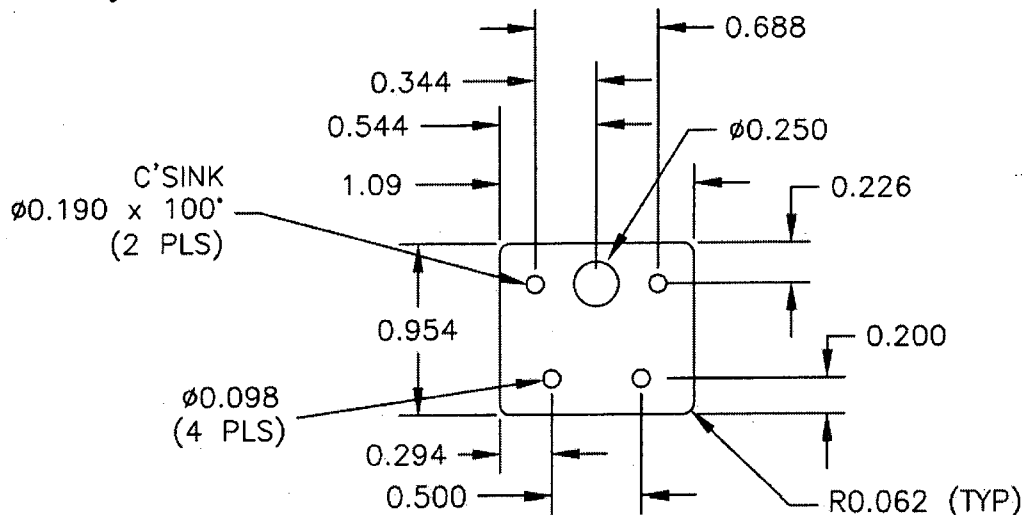
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

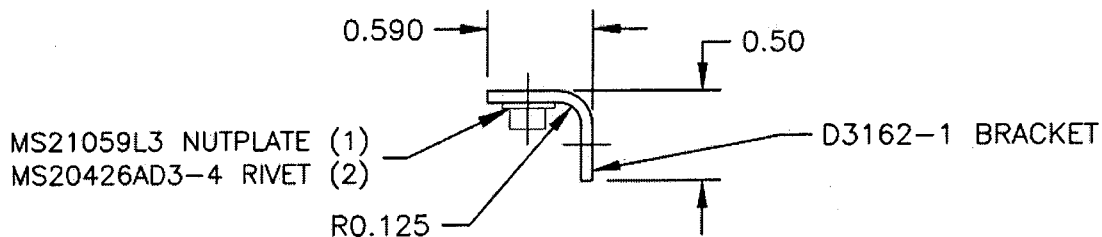


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3162	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED
04.11.23



D3162-1 BRACKET FLAT PATTERN



D3162-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

WORK ORDER

NO. 24709

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No : 0024709
Project Name : D3162-041
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3162-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 15
Amount Done : 0
Start Date : 10-26-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	24709
Description: bracket assembly		Part Number:	Δ3162-041
Inspection Dwg: A3162	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Same as w/o 24/6/88						

Measured by:	J.L	Audited by:	JML	Prototype Approval:	
Date:	05-11-13	Date:	05/11/13	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RE	

Date: Thursday, 11/17/2005 6:02:22 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY	
Job Number :	24709	Part Number :	D3162041	
Estimate Number :	10688	Drawing Number :	D3162 REV B	
P.O. Number :		Project Number :		
This Issue :	11/17/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	B	
First Issue :	1 / 1	Material :		
Previous Run :	24688	Due Date :	11/24/2005	Qty: 19 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est A 02.05.14 New Issue NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks. Blank size: 1.150" x 0.985" x .063" thick. Grain along .985

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA239 Stack of 7

Batch _____

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges .005 to 0.010

Form as per drawing

C'sink holes as per Dwg D3162

Date: Thursday, 11/17/2005 6:02:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24709

Part Number: D3162041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

8.0

MS21059L3

Nut Plate

9.0

MS20426AD34

RIVET

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per drawing

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion

